

Date: Tuesday, 3/20/2007 1:53:36 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET		
Job Number	: 31381		Part Number	: D30461		
Estimate Number	: 10733		Drawing Number	: D3046 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/20/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 4/15/2007 Qty: 20 Um: Each		
Previous Run	: 31228					
Written By						
Checked & Approved By						
Comment	: Est A 01.08.27 New Issue SM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174S12GA	17-4 STAINLESS STEEL SHEET
Comment: Qty.: 0.1260 sf(s)/Unit Total : 2.5200 sf(s) 2,6460 M174S12GA Batch: M103905		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3046 Dwg Rev: B Prog Rev: B		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Tumble & deburr Bend as per dwg D3046		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:53:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 31381

Part Number: D30461

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Jesu 17/20*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *VIA*

*FC 07 04 18 (20)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Do 7/04/18*

Job Completion



*U 07/04/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31381
Description: Lug Bracket	Part Number:	D3046-1
Inspection Dwg: D3046	Rev: AB	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	SAH	Audited by:	EP	Prototype Approval:	N/A
Date:	07/04/09	Date:	07/04/09	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	06.09.27	New Issue		KJ/JLM	JULY

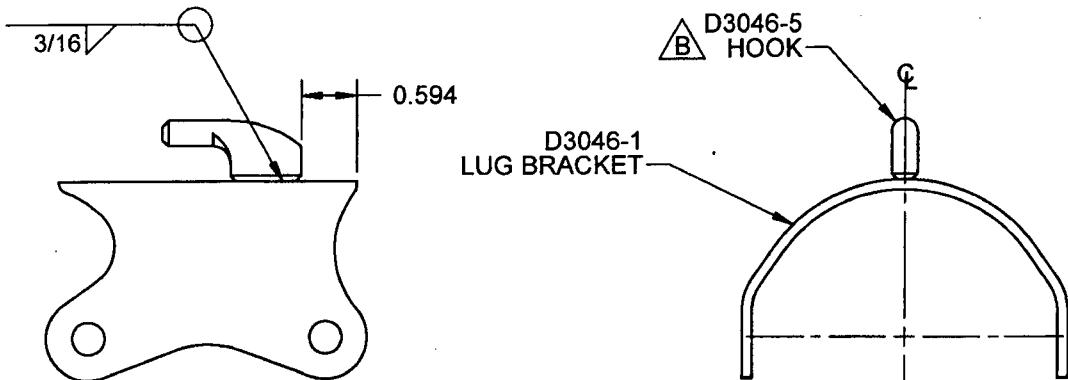
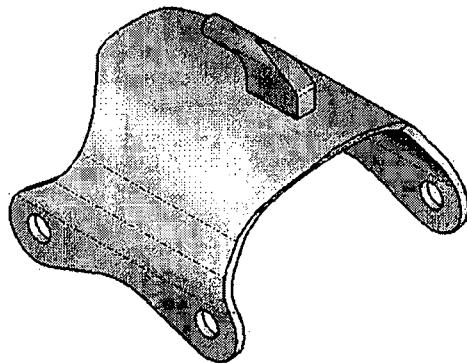
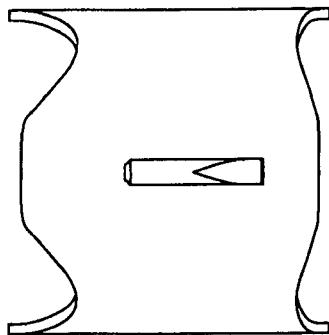
**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JH</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D3046</b>
DATE <b>06.10.26</b>		REV. B SHEET 1 OF 3 TITLE <b>LUG BRACKET ASSEMBLY</b> SCALE 1:2

RELEASED

06.11.13

REV	DATE	DESCRIPTION
A	01.08.23	NEW ISSUE
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL



### D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

B

**NOTES:**

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)  
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

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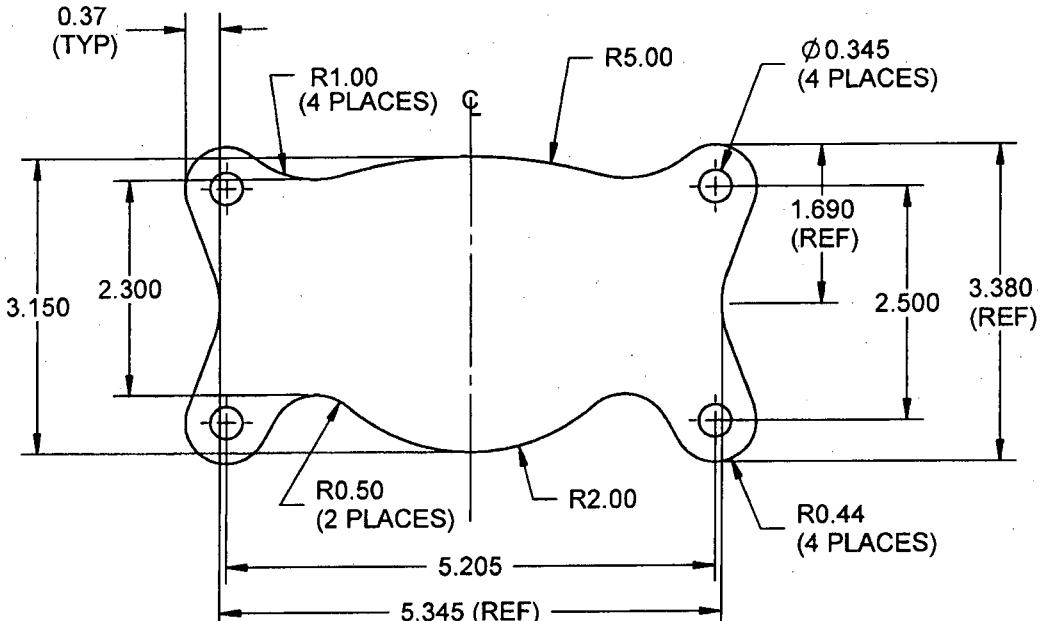
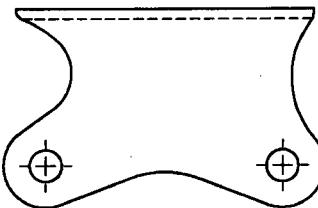
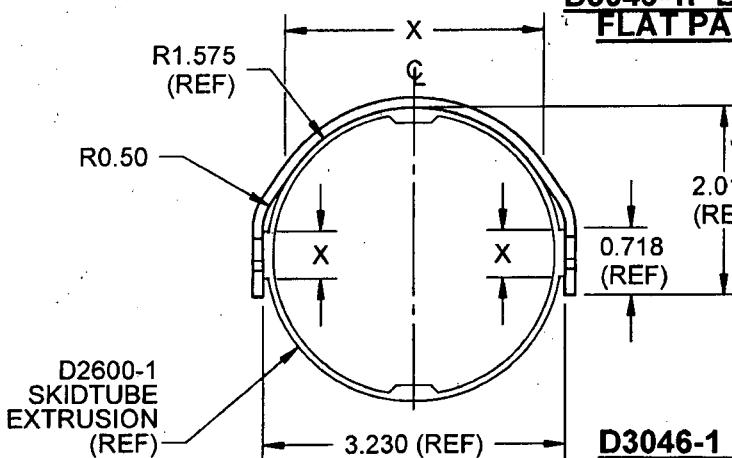
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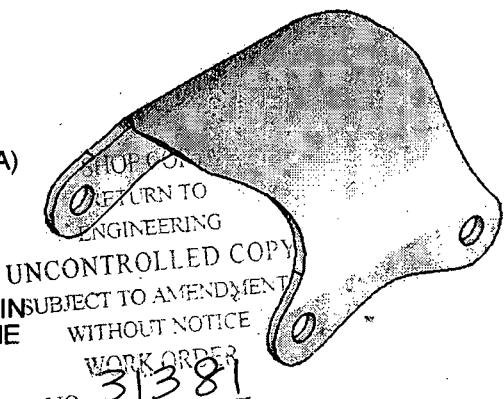
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3046	SHEET 2 OF 3
DATE	06.10.26	TITLE	SCALE
		LUG BRACKET ASSEMBLY	1:2

**D3046-1F BRACKET  
FLAT PATTERN****D3046-1 BRACKET  
BEND DETAIL****RELEASED**

06/16/13

**NOTES:**

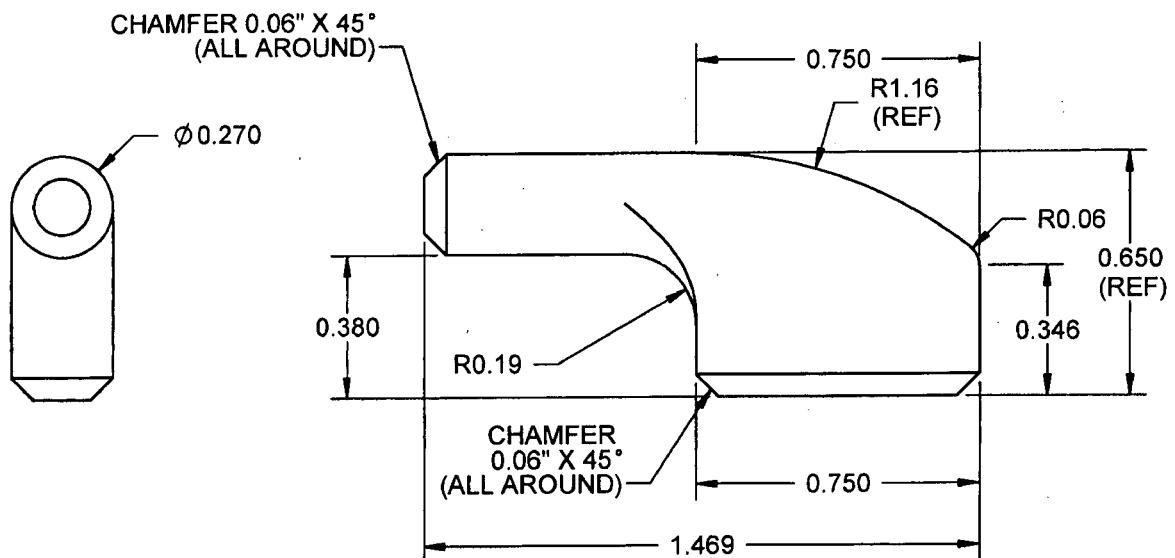
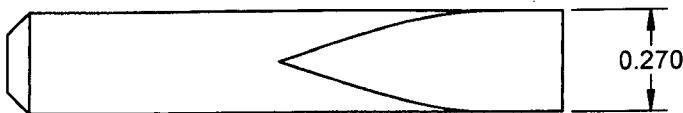
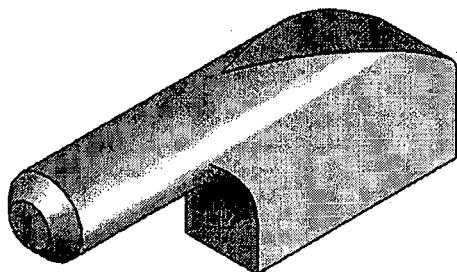
- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\text{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.

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**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D3046</b>	REV. B	SHEET 3 OF 3
DATE 06.10.26		TITLE <b>LUG BRACKET ASSEMBLY</b>	SCALE 2:1	

**D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643  
(REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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